

Date: Thursday, 05/03/2009 9:02:49 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET BASE ASSEMBLY (350)
<b>Job Number</b> :	43785A		
<b>Estimate Number</b> :	10189		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2221
<b>This Issue</b> :	05/03/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2221 REV G
<b>First Issue</b> :	26/11/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43779A	<b>Drawing Revision</b> :	G
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	05/12/2008
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

N/A

2.0	D22211	Rib
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rib

batch: B45938 → 1x

SL 09/03/05

3.0	D22215	Rib
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib

batch: B46082 → 2x

SL 09/03/05

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Job Number: 43785A

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	D22217	Rib
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B 46083 → 1x

dy 09/03/05

5.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

batch: B 42075 → 1x B 46084 → 1x

dy 09/03/05

6.0	D22351	Basket Rib
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B 46085 → 2x

dy 09/03/05

7.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B 43800 → 2x

dy 09/03/05

8.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B 45226 → 2x

dy 09/03/05

9.0	D3825041	Rib Assembly (Basket End)
-----	----------	---------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B 46087 → 2x

dy 09/03/05

10.0	D3826041	Rib / Gusset Assembly
------	----------	-----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B 46088 → 2x

dy 09/03/05

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Job Number: 43785A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B45609 → 1x

SL 09/03/05

12.0

D38331

Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B45896 → 2x

SL 09/03/09

13.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B45944

SL 09/03/09

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108775

SL 09/03/09 (1x)

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-11

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PD 03-11 (1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M110939  
Pressure wash MD/BR 09-03-11

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

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Job Number: 43785A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

~~19/110~~

Description :

1ST COAT:

START TIME:

14:15

OVEN TEMPERATURE:

400°

FINISH TIME:

14:45

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

umo/BR

09/03/11

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-12

(X1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



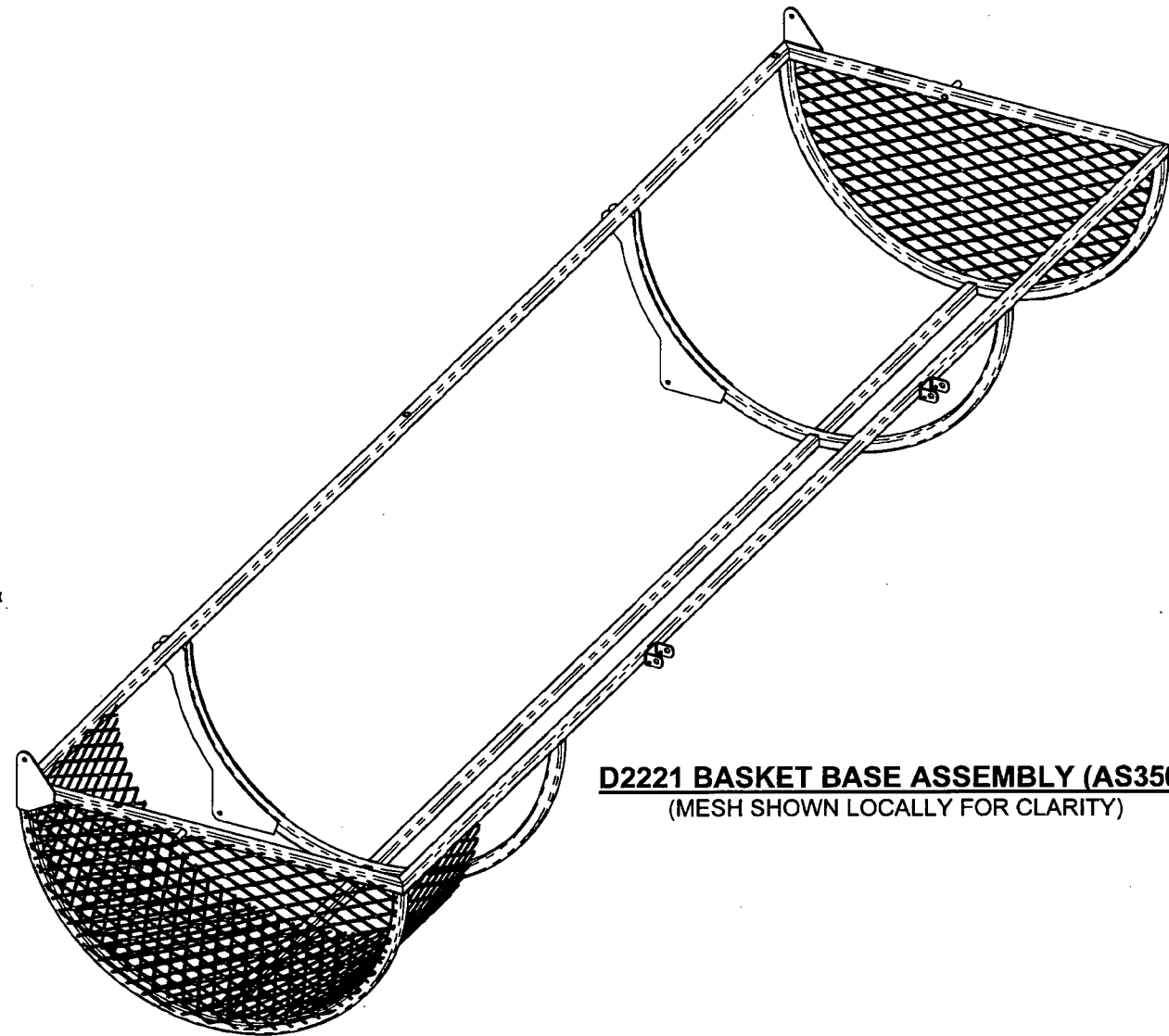
Comment: FINAL INSPECTION/W/O RELEASE

09/03/15

Job Completion



mf 09-03-13



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

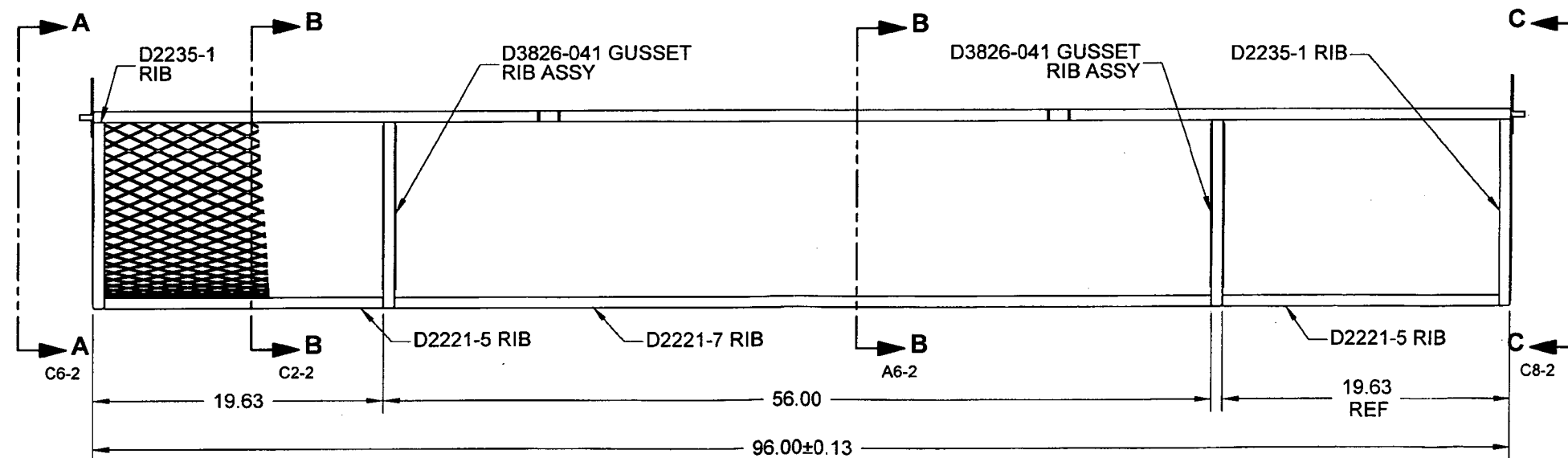
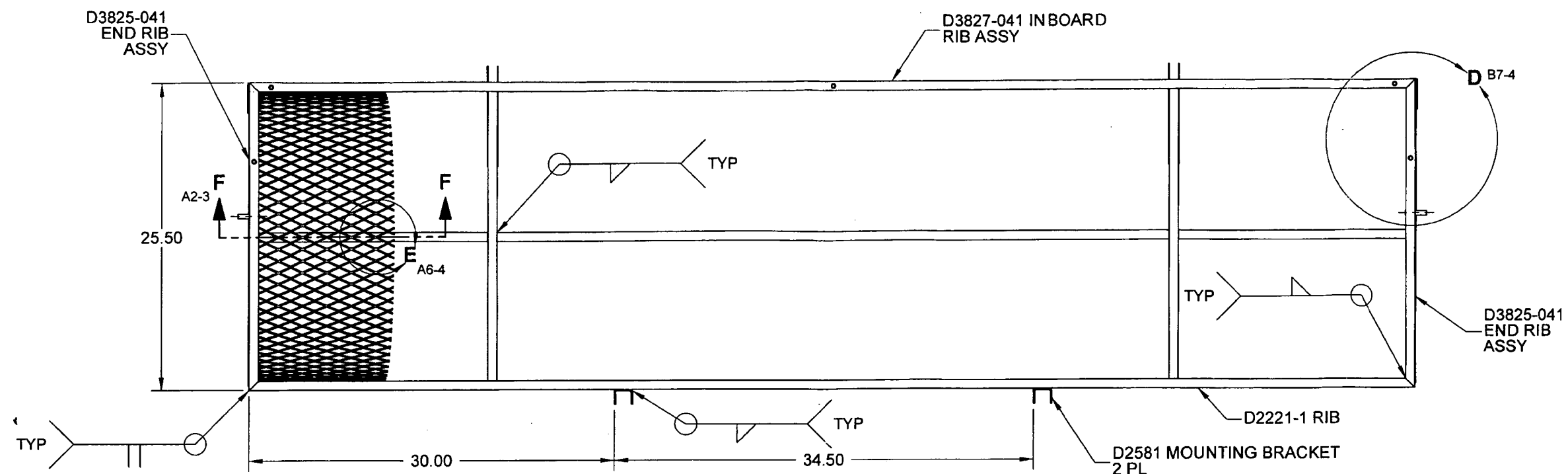


ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

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H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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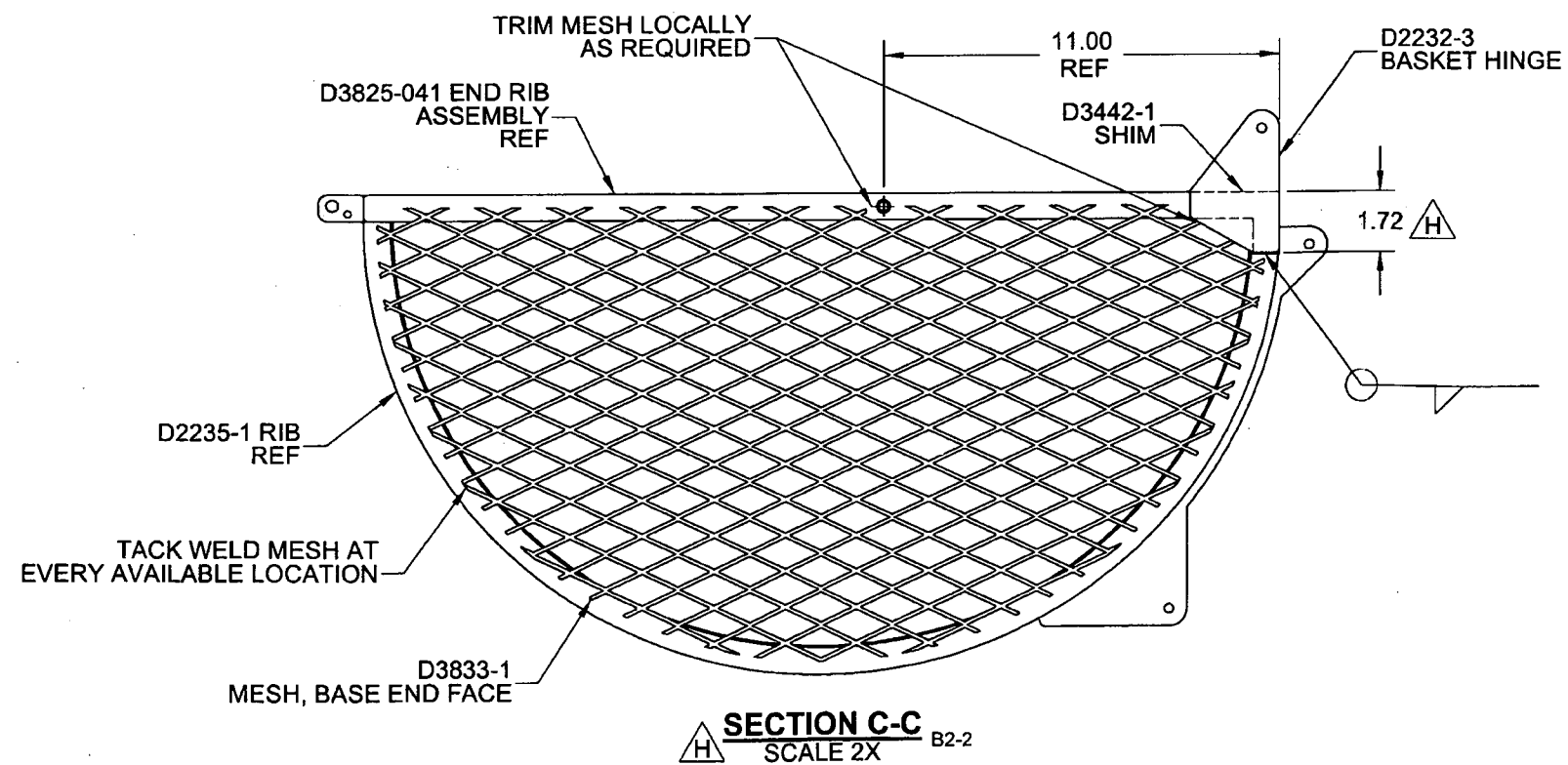
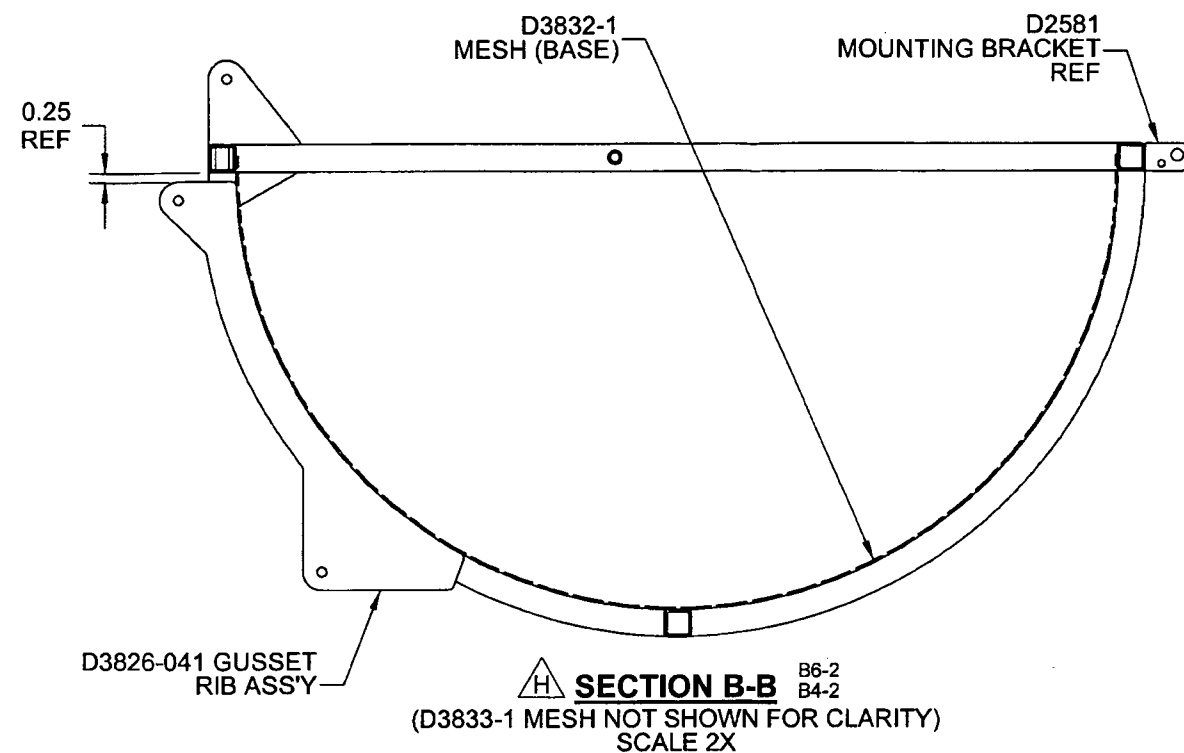
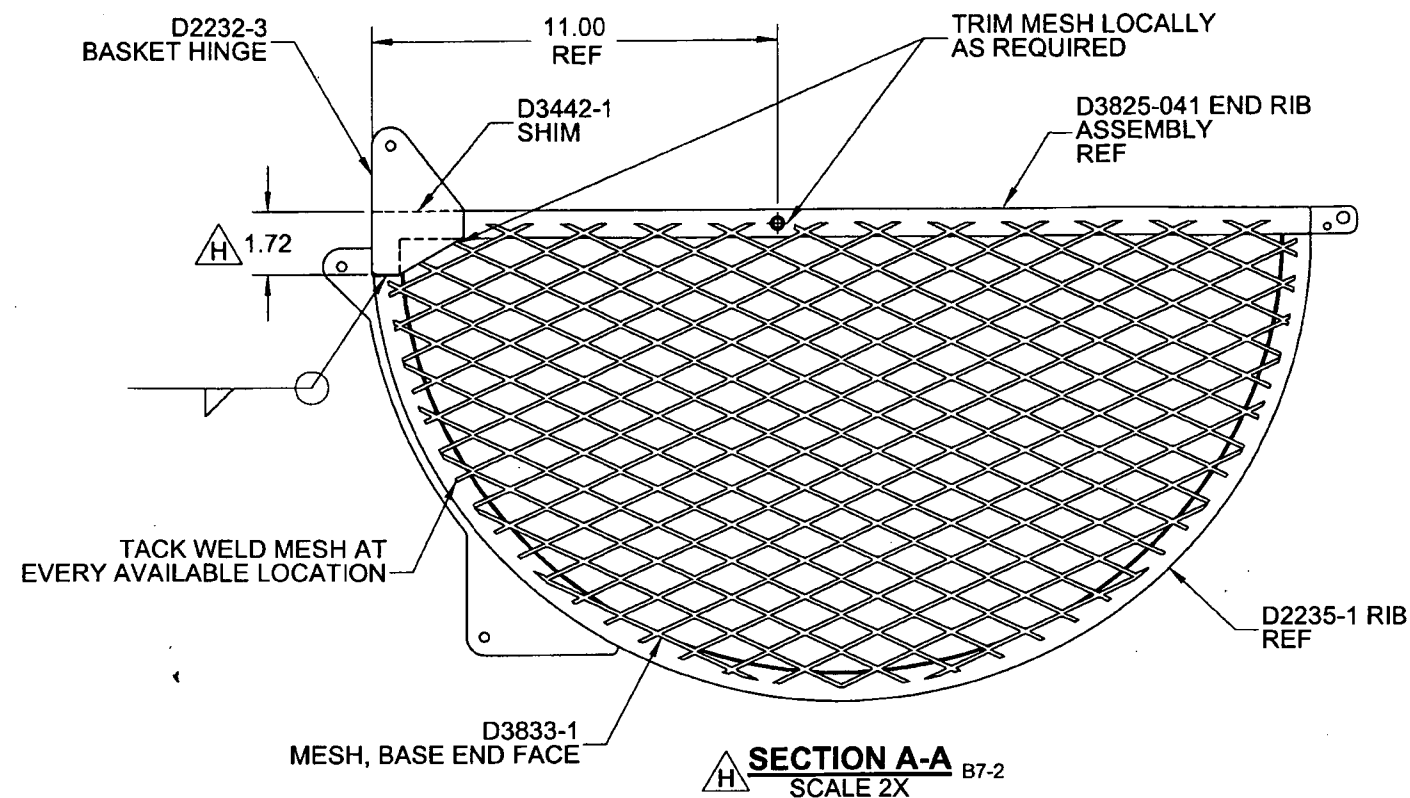


**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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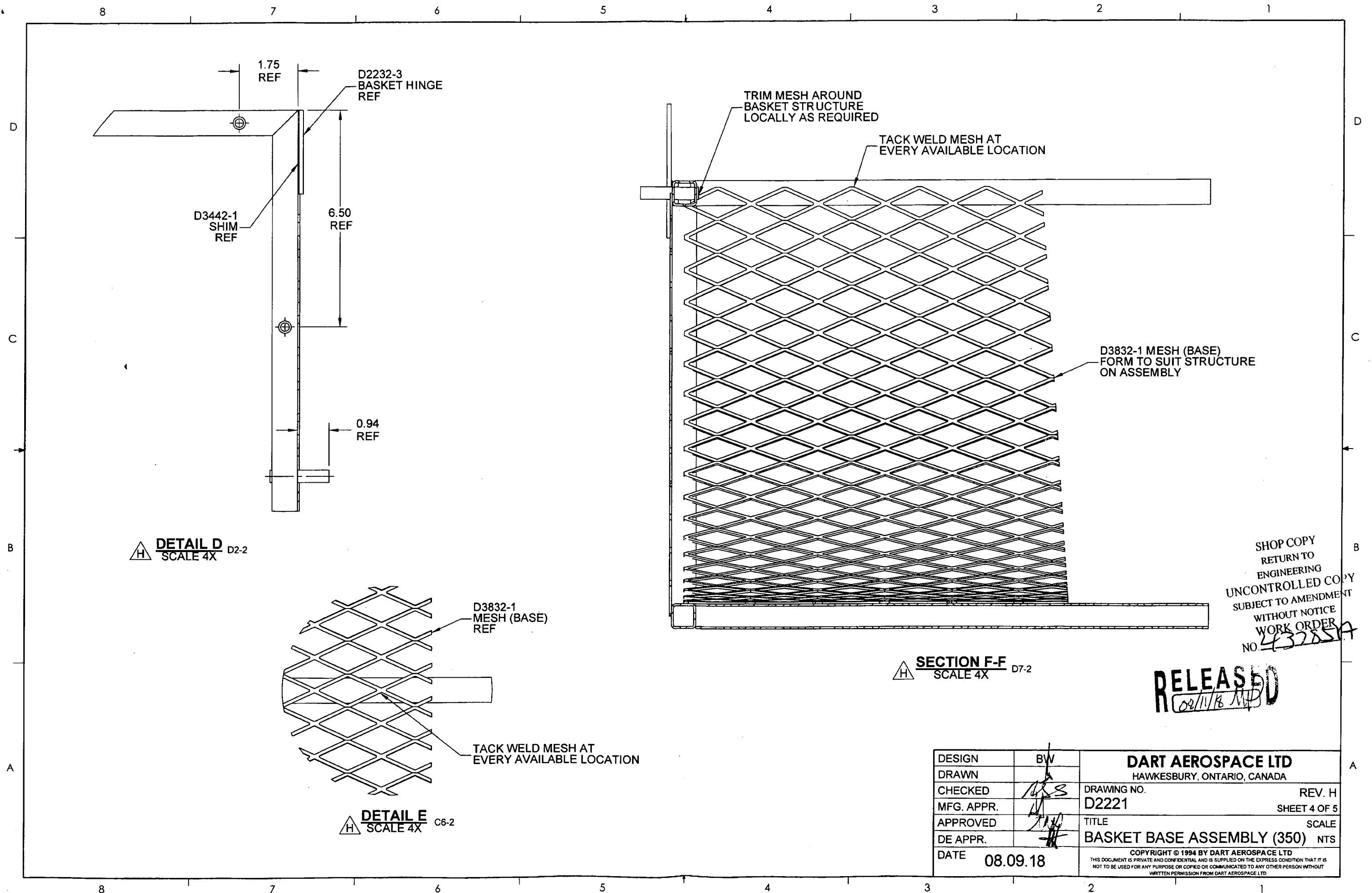
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
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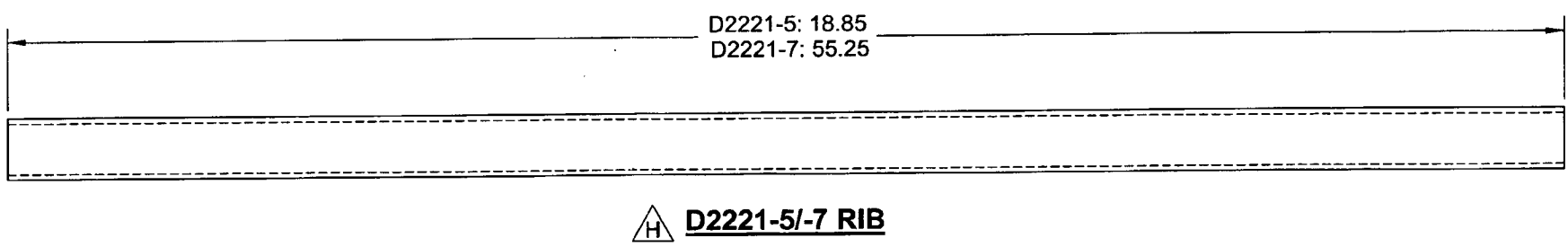
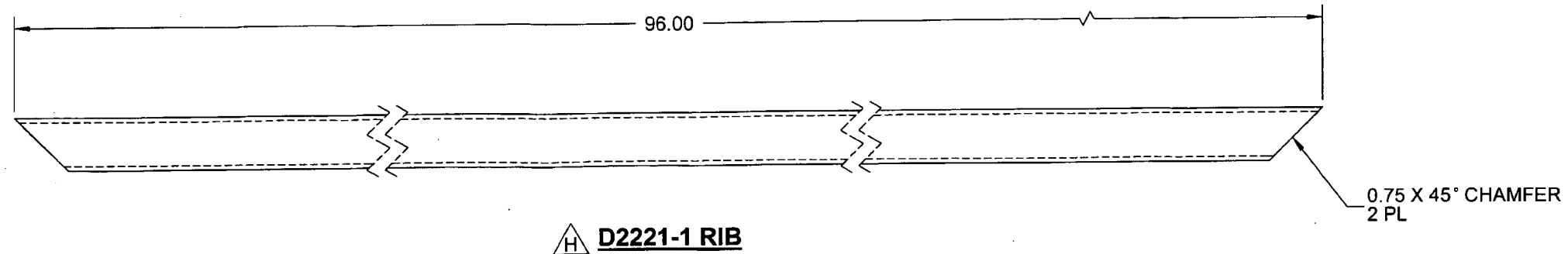
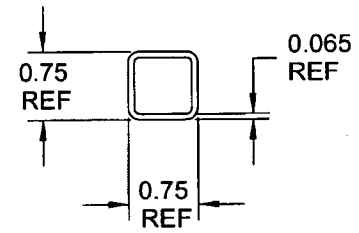
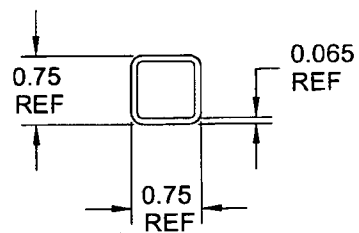
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RELEASE  
03/11/16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350)</b> NT	
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

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MFG. APPR.	ADS	D2221	SHEET 5 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	BASKET BASE ASSEMBLY (350)	NTS
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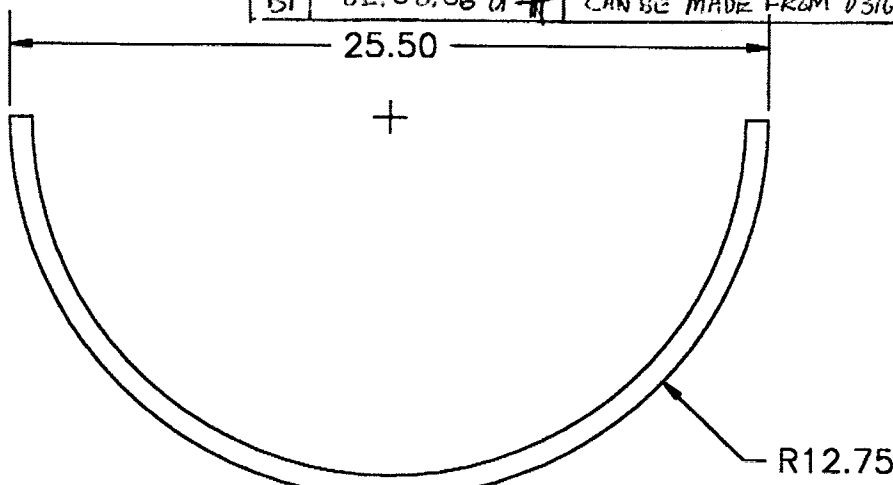
**DART**



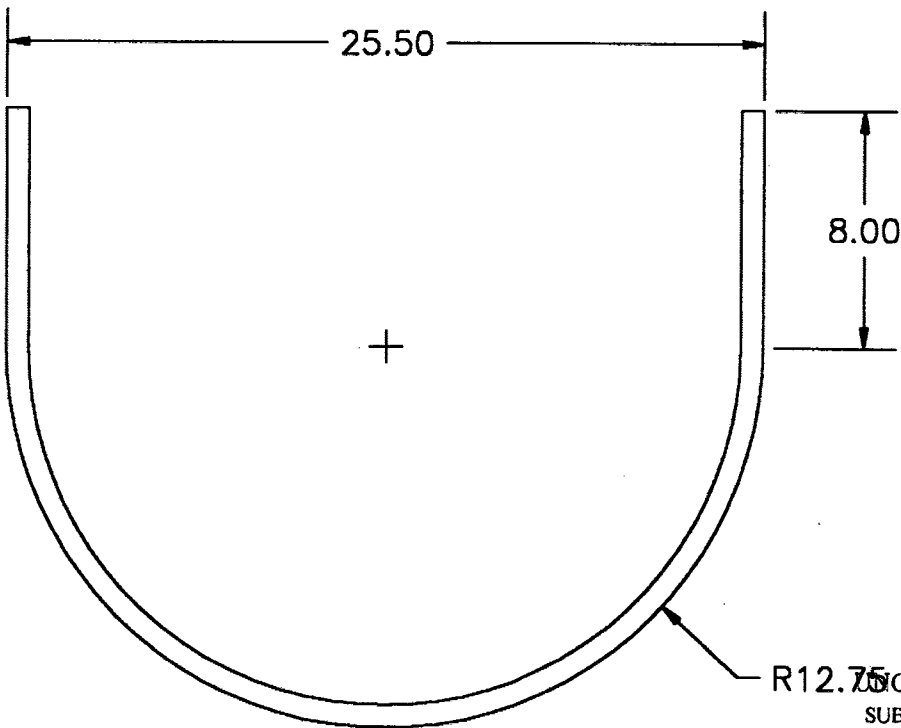
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI	02.08.06 <i>[Signature]</i>	CAN BE MADE FROM D3166-1
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RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *[Signature]*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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